

Date: Thursday, 17/08/2006 3:17:46 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP EXTRUSION
<b>Job Number</b> : 28215	
<b>Estimate Number</b> : 10058	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2622120C
<b>This Issue</b> : 17/08/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2622 REV C1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : C1
<b>Previous Run</b> : 27153	<b>Material</b> : N/A
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 15/09/2006 <b>Qty:</b> 184 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>[Signature]</u>	
<b>Comment</b> : Est. A: 02.11.12 New Issue KJ/RF	

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
<b>Comment:</b> PURCHASING Issue P/O: 1874 a) Extrude as per Dwg D2622 Rev. C b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required		
2.0	D2622120CP	Extrusion
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 160.0000 Each(s) Extrusion		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached		
4.0	QC6	DIMENSIONAL CHECK
<b>Comment:</b> DIMENSIONAL CHECK Inspect dimension per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester		



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 28215

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PE*

*PE 06.10.12*

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*SD 06/10/12*

Job Completion



*U 26.10.12*



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

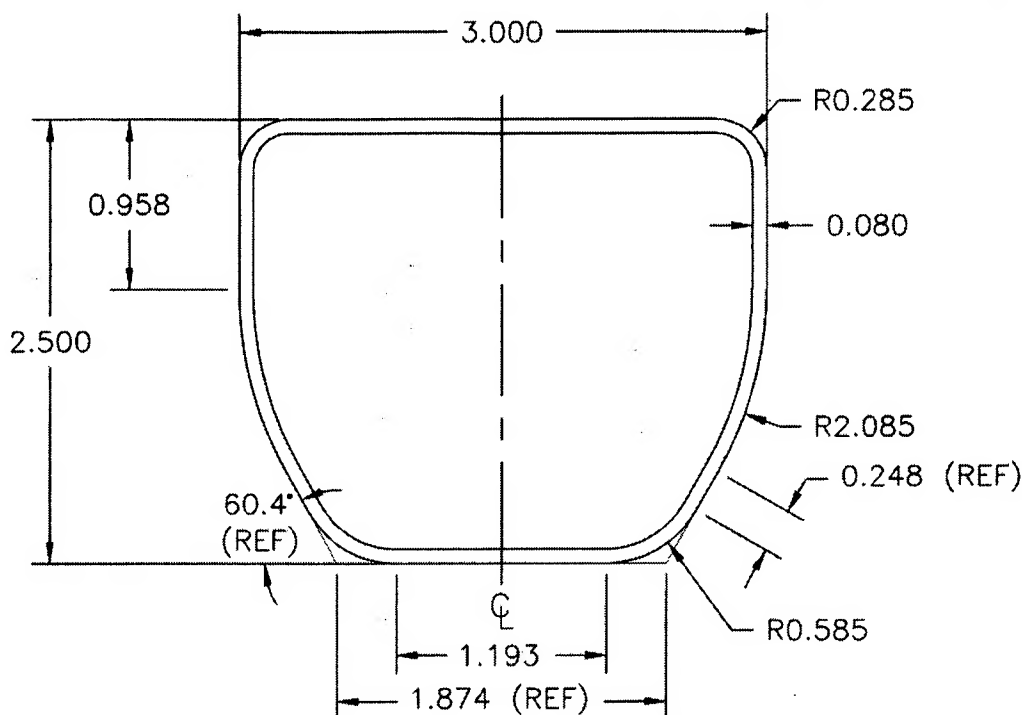
**NOTE:** Date & initial all entries






DESIGN KE	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
CI	GP 02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED  
02-09-11



**REFERENCE ONLY**

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A 
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE  
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9

# CERTIFICATE OF COMPLETION

<b>BON L CANADA INC</b>		500 EDWARD AVENUE RICHMOND HILL, ON -L4C 4Y9	
<b>Cert Date</b>	<b>Cert No</b>	<b>Sales Order</b>	<b>Page</b>
10/09/06	148498	36474	1
<b>Expt. PC</b>	<b>B/L No</b>	<b>Lot</b>	<b>Date</b>
1874 ✓	00321502	36474010	10/09/06
<b>Sold To</b>		<b>Ship To</b>	
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	
<b>Item No</b>	<b>Part No</b>	<b>Item Description</b>	<b>Cust Part</b>
1.000	DAA-897123-1	120" Mill 6061 T6	D2622 ✓
<b>Gross Weight</b>	801' KGS		
<b>Net Qty</b>	759 KG		
<b>Specification</b>	AMS-QQ-A-200/8 & ASTM B221-00		
		184 PC	561 M
		3 PKG	
		Die Desc	
		Bend/	

### Mechanical Tests:

Test No.	Tensile MPA / KSI
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Yield  
MPA / KSI

%Elongation

## Conductivity

Bend/

Drift HREW

Chemical Analysis:

SI      FE      CU

.65 .27 .26 .05 .89 .06 .007 .08 .000 .009 .02 .000 .00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada